

5145

SPLIT

2

<b>DART AEROSPACE LTD.</b>	<b>Work Order:</b>	24433
<b>Description:</b> Saddle Fitting, Fwd (Outboard/Inboard)	<b>Part Number:</b>	D2571/D2572
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	<b>Qty:</b>	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	KJ	05.10.12	8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B24893	JG	05/12/23	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B21817-A	JG	05/12/23	8
4	MV	Fixturing W/O No. / Fixturing Inspection last completed / by /	/	/N/A/	/
5	MV	Program Batch No. 24433 Double check by: Ep	JL	05.12.28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	MS/JL	06/01/03	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	MS/JL	06/01/03	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	MS/JL	06/01/03	8
9	MV	Machine keyway as per dwg D2571 & D2572	MS/JL	06/01/03	8
10	MV	Deburr and remove all machining marks	MS/JL	06/01/03	8
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	MS/JL	06/01/03	8
12	QC1	Inspect all dimensions to dimension sheets	MS/JL	06/01/03	8
13	QC7	Second inspection	Ep	06/01/08	7
14	FP	Acid etch and alodine as per QSI 005 4.1	FF	06/01/11	7/5
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MM	06 01 16	7/5
16	QC3	Inspect Powder Coat	L	06/1/17	7/5
17	ST	Identify and Stock. Loc 372	L	06/1/17	7/5
18	AC	Cost / Part	Sue	06-01-18	
19	DC	Close W/O Inspection Level 21	QJ	06/01/18	

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/01/09	9	- new tool to cut groove, tool wasn't sharpened to the right dimension, 1 saddle 2571 affected		Scrap: destroy replace tool with proper size. Destroy original tool	MS 06/01/09			
06/01/09	9	- new tool to cut groove, tool wasn't sharpened to the right dimension, 1 saddle 2572 affected.		Scrap: destroy Replace tool with proper size. Destroy original tool	MS 06/01/09			

Part No: D2571/D2572 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24433
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.749	1.750	1.752		
C	3.495	3.505		3.500	3.500	3.501	3.504		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.010	8.000		
F	0.490	0.510		.501	.500	.507	.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.500	.499	.498	.497		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		.568	.566	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.872		
P	0.115	0.135		.128	.128	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.253	.249	.255		
S	0.115	0.135		.126	.128	.130	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.962	2.962		
V	0.230	0.250		.240	.241	.247	.248		
W	0.115	0.135		.118	.125	.125	.127		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.629	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.250	.260	.252		
AE	1.375	1.395		1.387	1.388	1.386	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.255	.252	.254	.245		
AI	2.000	2.020		2.001	2.002	2.002	2.001		
Accept/Reject				Reject					
AJ				1.023	1.043	1.030	1.030		
Measured by:				JL	Audited by:				
Date:				05-12-28	Date:				
					06/01/09				

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED  
05.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24433
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.751	1.751	1.752	1.751		
C	3.495	3.505		3.500	3.501	3.500	3.501		
D	1.745	1.755		1.751	1.751	1.751	1.751		
E	7.990	8.010		8.002	8.001	8.002	8.004		
F	0.490	0.510		.499	.498	.499	.499		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.504	.503	.500	.500		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.565	.569	.572	.572		
L	1.174	1.184		1.180	1.180	1.179	1.180		
M	1.490	1.500		1.496	1.493	1.494	1.494		
N	2.495	2.505		2.501	2.500	2.500	2.499		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		.127	.128	.128	.129		
Q	0.115	0.135		.128	.135	.132	.130		
R	0.240	0.260		.249	.248	.255	.257		
S	0.115	0.135		.129	.127	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.964	2.962		
V	0.230	0.250		.241	.244	.244	.245		
W	0.115	0.135		.128	.130	.130	.127		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.362	.362	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.375	1.395		1.383	1.384	1.384	1.385		
AF	0.115	0.135		.134	.135	.135	.130		
AG	0.240	0.280		.270	.269	.258	.242		
AH	0.240	0.260		.249	.250	.253	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject				2.001					
A3   0.023   0.043				1.030	1.030	1.030	1.030		
Measured by: MB				Audited by: CN					
Date: 06/01/03				Date: 06/01/09					

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	#

RELEASED  
05.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 24433
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.751		
C	3.495	3.505		3.500	3.500	3.500	3.503		
D	1.745	1.755		1.750	1.749	1.750	1.751		
E	7.990	8.010		8.001	7.998	7.991	8.005		
F	0.490	0.510		.500	.498	.498	.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.500	.498	.497	.499		
J	1.174	1.184		1.179	1.179	1.181	1.180		
K	0.558	0.578		.568	.565	.569	.568		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.501	2.502	2.500		
O	3.869	3.879		3.874	3.874	3.873	3.872		
P	0.115	0.135		.126	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.253	.250	.256		
S	0.115	0.135		.124	.124	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.964		
V	0.230	0.250		.240	.237	.241	.239		
W	0.115	0.135		.130	.127	.131	.129		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.762		
Z	0.352	0.372		.358	.361	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.628	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.250	.251		
AE	1.375	1.395		1.388	1.388	1.387	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.265	.248	.245		
AH	0.240	0.260		.247	.251	.249	.254		
AI	2.000	2.020			2.000	2.005	2.000		
Accept/Reject									
AS 1.023 1.043 1				1.030	1.030	1.030	1.030		
Measured by: JL				Audited by: EN					
Date: 05.12.28				Date: 06/01/09					

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED  
05.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 24433
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.751	1.752	1.751	1.752		
C	3.495	3.505		3.502	3.502	3.500	3.502		
D	1.745	1.755		1.751	1.751	1.751	1.750		
E	7.990	8.010		8.000	8.001	8.002	8.005		
F	0.490	0.510		.505	.506	.500	.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.503	.500	.500	.500		
J	1.174	1.184		1.178	1.178	1.150	1.179		
K	0.558	0.578		.572	.571	.572	.572		
L	1.174	1.184		1.178	1.178	1.150	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.870	3.870	3.870		
P	0.115	0.135		.128	.127	.125	.128		
Q	0.115	0.135		.134	.135	.135	.135		
R	0.240	0.260		.254	.254	.255	.251		
S	0.115	0.135		.125	.125	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.965		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.126	.125	.127	.127		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.363	.363	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631	.627	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.255	.256		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		.132	.129	.129	.129		
AG	0.240	0.280		.246	.245	.247	.246		
AH	0.240	0.260		.251	.250	.250	.250		
AI	2.000	2.020		2.002	2.001	2.000	2.001		
<b>Accept/Reject</b>									
As 1.043 1.023				1.030	1.030	1.030	1.030		
Measured by: MS				Audited by: En					
Date: 06/01/03				Date: 06/01/03					

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED  
2005.05.05





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 05, 2005  
10:49 am

Work Order No : 0024433S  
Project Name : D2572  
Project For :  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2572  
Description : Saddle, Fwd, In  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 10-05-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden :	0.00	0.00	0.00		
	=====	=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 05, 2005  
10:49 am

Work Order No : 0024433  
Project Name : D2571/72  
Project For : WK545  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2571  
Description : Saddle, Fwd, Out  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 10-05-05  
Est Finish Date : 11-10-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00